

Work Order ID 80640

80640

Page 1

February-24-12 3:23:10 PM

Item ID: D4436-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Aft Bracket Assembly
 Start Date: 24/02/2012 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 15/03/2012 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 12/02/27 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4436	A								

100 0.00
 100
 Small Fab Memo 0.00
 Small Fab Assemble as per dwg and intall grommet

110 QC5- Inspect part completeness to step on W/O 0.00
 110
 QC Memo 0.00
 Quality Control

160 Identify as per dwg & Stock Location 441 0.00
 160
 Packaging Memo 0.00
 Packaging

Signature: [Handwritten Signature] 12/03/28 (10)

(40)

Signature: [Handwritten Signature] 04/3/28 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80640

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

10

Cust Item ID:

10

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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0.00

170

QC

Memo

0.00

Quality Control

12/3/29 JJ

Q12-03-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

February-24-12 3:23:14 PM

Page 1

Work Order ID: 80640

80640

Parent Item: D4436-041

D4436-041

Parent Item Name: Aft Bracket Assembly

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC
RevB 11.12.22 per PA2 EC verified by:JLM
12.01.24 PER DWG REV.A DD VERF:EC

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4440-1		Manufactured	No			100	Each	20.0000	1	10			
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D4440-1

Grommet

Location	Loc Qty	Loc Code
prelim	2	
74759	2	
PREst	8	
77917	8	
ST139F	10	
79372	10	

**

EP 12/03/27
B80645 (10x)

D4435-043		Manufactured	No			100	Each	4.0000	1	10			
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D4435-043

Mount Bracket Assembly

Location	Loc Qty	Loc Code
ENG	1	
78249	1	
ST	3	
79612	3	

**

EP 12/03/27
B80643 (10x)

D4436-043		Manufactured	No			100	Each	2.0000	1	10			
-----------	--	--------------	----	--	--	-----	------	--------	---	----	--	--	--

D4436-043

Aft Outboard Bracket Assembly

Location	Loc Qty	Loc Code
ENG	2	
77908	1	
79614	1	

**

EP 12/03/27
B80648 (10x)

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80640

80640

Parent Item: D4436-041

D4436-041

Parent Item Name: Aft Bracket Assembly

Start Date: 24/02/2012

Required Date: 15/03/2012

Start Qty: 10.00

Required Qty: 10.00

D4436-045

Manufactured No

100 Each

0.0000

1

10

D4436-045

Aft Inboard Bracket Assembly

AN525-832R6

Purchased No

100 Each

511.0000

4

40

AN525-832R6

Screw

Location

Loc Qty

Loc Code

ST345

511

120308

11

120560

500

**

**

Ep 12/03/27
Ep 12/03/27

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

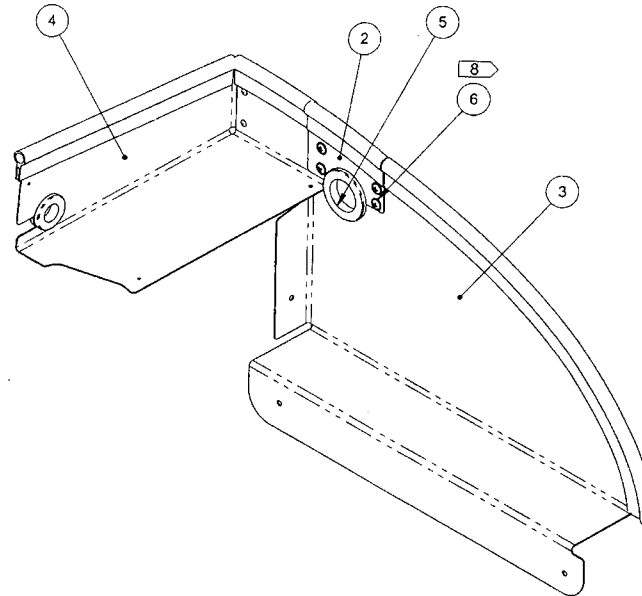
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NOTE: Date & initial all entries

ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4436-041	AFT BRACKET ASSEMBLY
2	1	D4435-043	BRACKET ASSEMBLY
3	1	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
4	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW



D4436-041 AFT BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.31 lbs
- 8) TORQUE SCREW TO 12-15 (in-lb)

UNCONTROLLED COPY
SUBMIT TO
WITHOUT NOTICE
WORK ORDER
NO. 80640 M.C.J
12/02/27

RELEASED
12 2012-01-23
MJP

A		NEW ISSUE		RF	12.01.17
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	RF			SHEET 1 OF 7	
CHECKED	RF	DRAWING NO. D4436		SCALE	
MFG. APPR.	RF	TITLE		NTS	
APPROVED	RF	COVER ASSEMBLY			
DE APPR.	RF	DATE 12.01.17			
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W/O:		WORK ORDER CHANGES					
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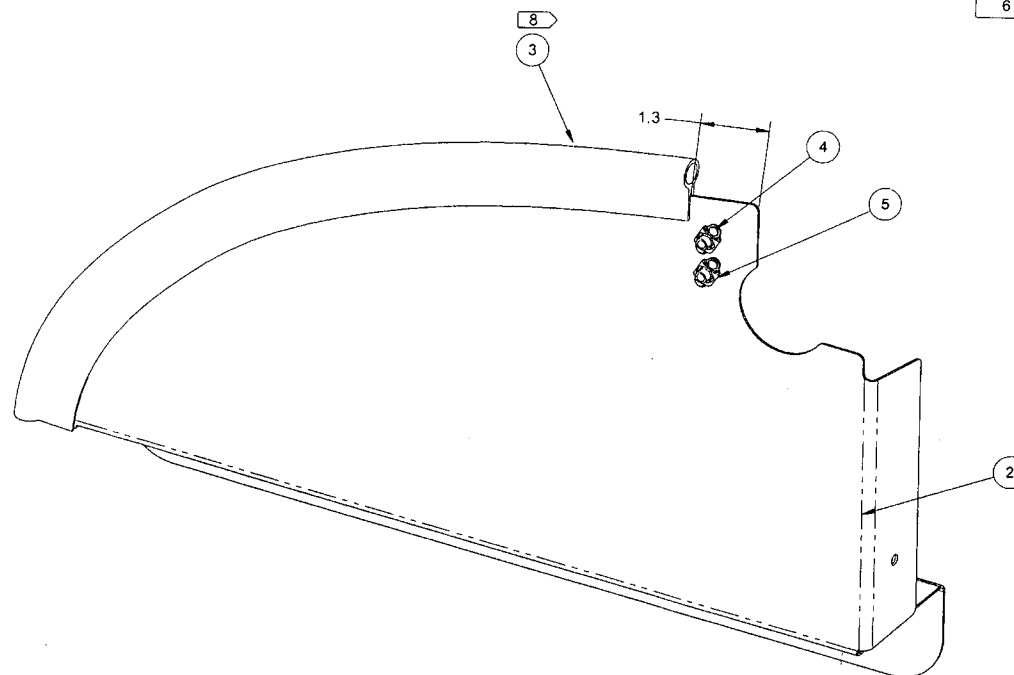
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ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4441-1-160	RUBBER SEAL
4	4	MS20426AD3-2	RIVET
5	2	MS21075L08	NUT PLATE
6	A/R	3M 1300/1300L	ADHESIVE



D4436-043 AFT OUTBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

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80640

2012-01-23

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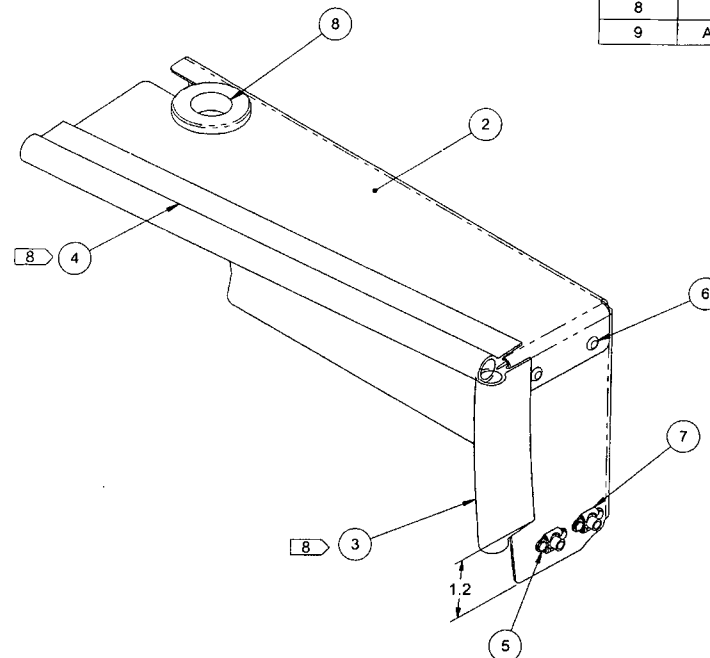
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY .045	PART NUMBER	DESCRIPTION
1	X	D4436-045	AFT INBOARD BRACKET ASSEMBLY
2	1	D4436-3	BRACKET
3	1	D4441-1-038	RUBBER SEAL
4	1	D4441-1-100	RUBBER SEAL
5	4	MS20426AD3-2	RIVET
6	2	MS20470AD4-3	RIVET
7	2	MS21075L08	NUT PLATE
8	1	MS35489-19	GROMMET
9	A/R	3M 1300/1300L	ADHESIVE



D4436-045 AFT INBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE,
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

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MFG. APPR.	<i>[Signature]</i>	D4436	SHEET 3 OF 7
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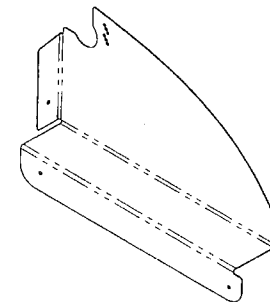
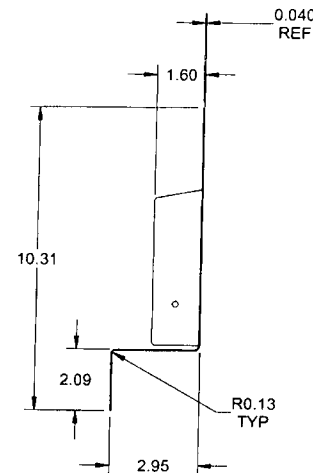
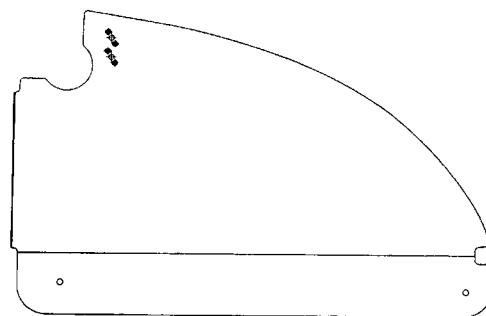
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



80640

D4436-1 BRACKET

RELEASE
2012-31-23

NOTES:

- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

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MFG. APPR.	<i>[Signature]</i>	D4436	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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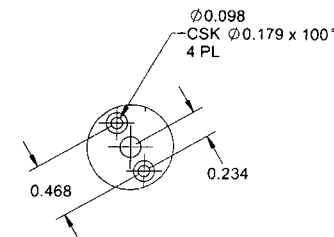
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

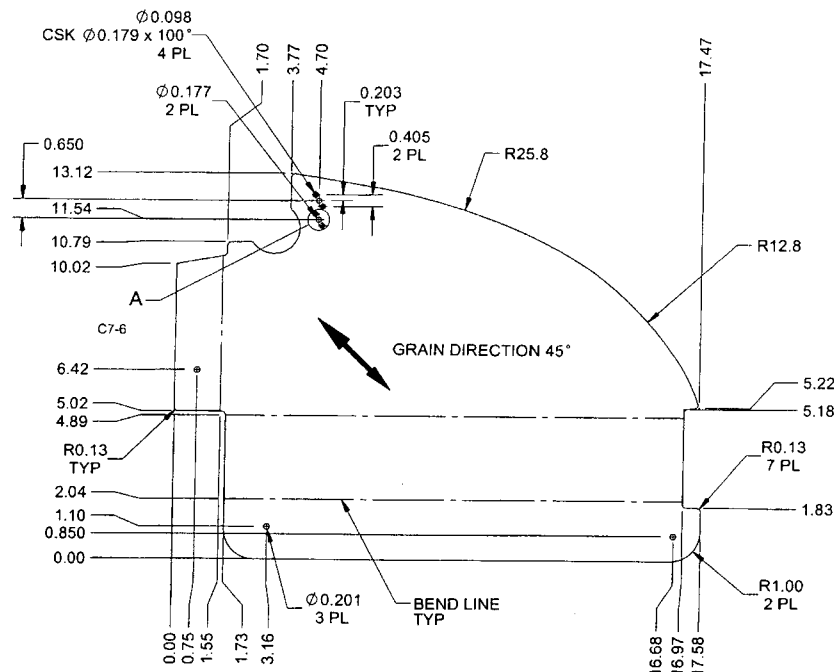
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DETAIL A C8-6
SCALE 4X, TYP



D4436-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4436 REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 7
APPROVED	<i>[Signature]</i>	TITLE COVER ASSEMBLY SCALE NTS
DE APPR.	<i>[Signature]</i>	
DATE	12.01.17	

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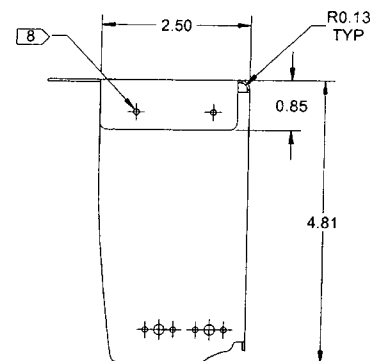
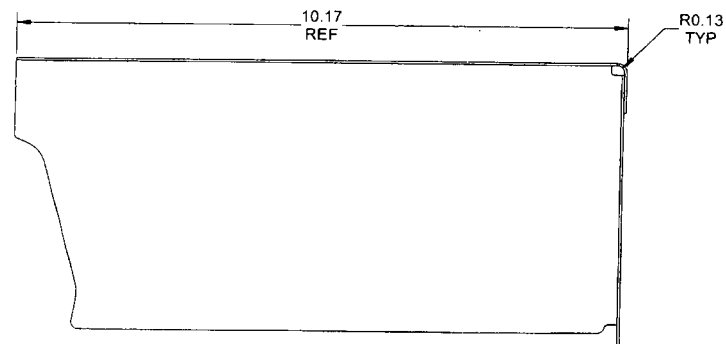
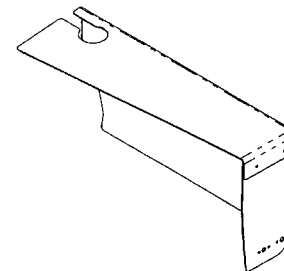
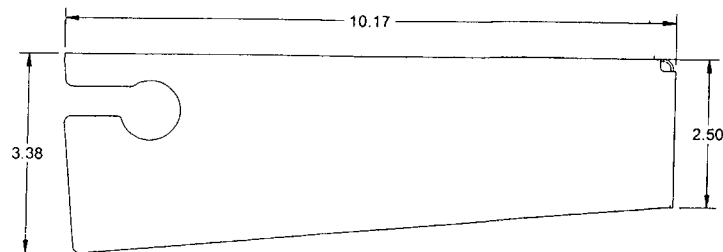
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NOTE: Date & initial all entries



80640

D4436-3 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) TRANSFER $\varnothing 0.129$ HOLES THRU 2 PLACES

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4436	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 6 OF 7	
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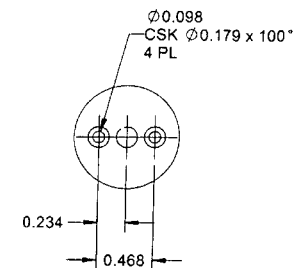
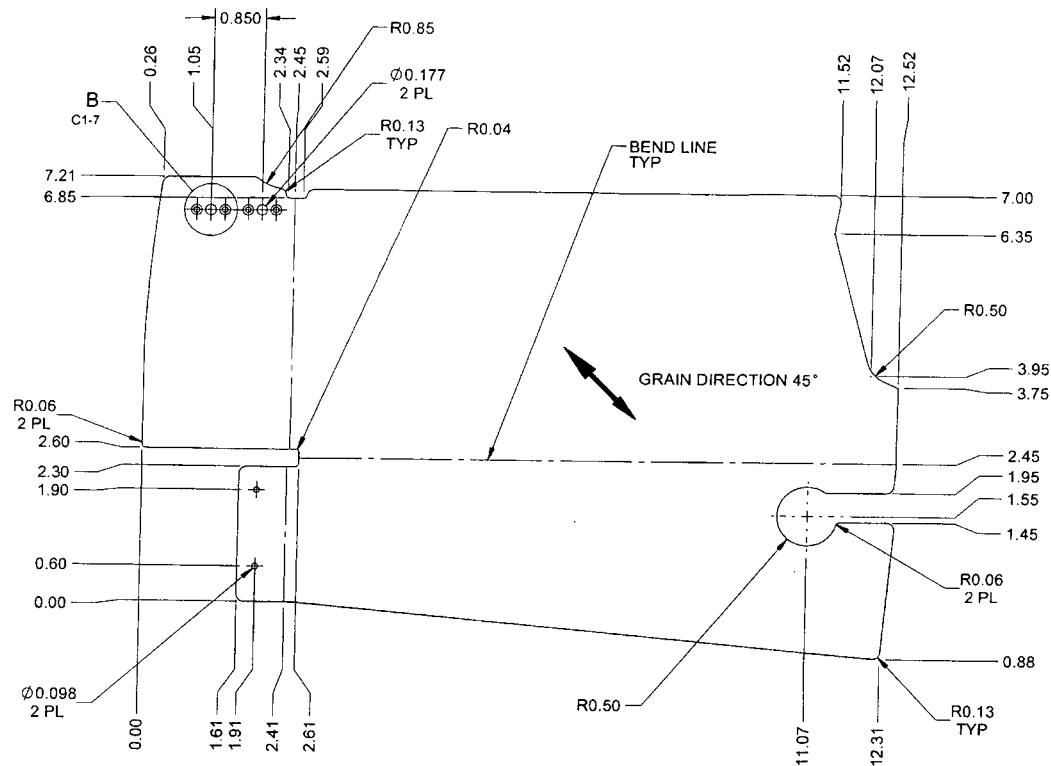
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NOTE: Date & initial all entries



DETAIL B D7-7
SCALE 2X, TYP





80040

D4436-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

RELEASED
11 2012 -31- 23
MD

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4436	SHEET 7 OF 7
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